

154390

Monday, December 12, 2016 2:26:03 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Draw Nbr	Revision Nbr			
MPP-195	N/C	DAS 6	DEC 15 2016	

DAS
28
9-89

DEC 19 2016

) **DAS**
6 — DEC 15 2016 **DAS**
 9-89 9-89

DAS
28
9-89

DEC 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval																		
Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Work Order ID 154390

Monday, December 12, 2016 2:26:04 PM

154390

Page 2

Item ID: 647.7328

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/16/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 647.7328 Location : FG109								
	<i>Sold</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

DEC 19 2016

DAS
21
9-89

DEC 19 2016



DEC 19 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
3				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, December 12, 2016 2:26:08 PM

Page 1

Work Order ID: 154390

154390

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.12.12 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7701 *647 7701* Strut Assembly		Manufactured	No				Each	0.0000	**	2		DEC 15 2016	DAS 28 6 9-89
647.0112 *647 0112* Strut Bracket		Manufactured	No				Each	41.0000	**	2		DEC 15 2016	DAS 28 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK107				41					
				150114				16					
				150895				15					
				151894				10					
AN44-12A *AN44-12A* Eyebolt		Purchased	No				Each	12.0000	**	2		DEC 15 2016	DAS 28 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST339				12					
				124263				12					
AN665-34R *AN665-34R* Clevis		Purchased	No				Each	84.0000	**	2		DEC 15 2016	DAS 28 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				over008				47					
				153852				47					
				ST330				37					
				M135948				11					
				M136182				26					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Picklist Print

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Page 2

Work Order ID: 154390

154390

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-11A Purchased No

Each 686.0000 2

AN3-11A

Bolt

**

DEC 15 2016

DAS 28
6 9-89

DAS 27
9-89

Location	Loc Qty	Loc Code
over003	664	
153855	564	
m136192	100	
ST349	22	
m135767	22	

AN4C7A Purchased No

Each 136.0000 2

AN4C7A

BOLT

**

DEC 15 2016

DAS 28
6 9-89

DAS 27
9-89

Location	Loc Qty	Loc Code
OVER002	124	
m135864	70	
m136295	54	
ST345	12	
m135470	12	

MS21042-08 MS21042L08 Purchased No

Each 0.0000 2

MS21042-08

USE MS21042L08

**

136199 DEC 15 2016

DAS 28
6 9-89

DAS 27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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OTHER : _____					

Picklist Print

Monday, December 12, 2016 2:26:08 PM

Page 3

Work Order ID: 154390

154390

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

2,602.000

2

MS21042L4

Nut

**

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

196

m135058

196

OVER007

1500

m136182

500

m136295

1000

ST303

888

153851

3

m135864

385

m135979

500

AN316C4R

Purchased

No

Each

89.0000

2

AN316C4R

Nut, Jam

**

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST331

89

153850

50

m135840

4

m136192

35

MS27039-08-13

Purchased

No

Each

471.0000

2

MS27039-08-13

Screw

**

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

over006

325

153849

325

ST278

146

124326

46

m136199

100

Monday, December 12, 2016 2:26:08 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

Picklist Print

Monday, December 12, 2016 2:26:08 PM

Page 4

Work Order ID: 154390

154390

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

2,081.000

19

NAS1149FN832P

Washer

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

449

M135058

449

ST260a

1500

M136182

1500

ST263

132

M135058

132

Each

1,775.000

4

NAS1149C0432R

Purchased

No

NAS1149C0432R

WASHER

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136182

1000

ST266

402

m135979

402

Each

1,629.000

2

NAS1149F0532P

Purchased

No

NAS1149F0532P

Washer

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1029

18057

1029

DAS
27
9-89

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Picklist Print

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Monday, December 12, 2016 2:26:08 PM

Work Order ID: 154390

154390

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

601.2045

Purchased

No

Each

15.0000

1

601 2045

RTV (LOCTITE 598)

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK096

7

m136171

7

GA

8

m134260

8

MS27039-08-19

Purchased

No

Each

267.0000

5

MS27039-08-19

Screw

134702

MS27039-08-27

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

164

m135948

164

ST277

103

m136042

1

m136199

52

m136301

50

MS21042L08

Purchased

No

Each

929.0000

5

MS21042L08

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

528

m135274

28

m135978

500

ST303

401

m135948

1

m136199

200

m136301

200

DAS 28 9-89
DEC 15 2016

DAS 28 9-89
DEC 15 2016

DAS 28 9-89
DEC 15 2016

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Monday, December 12, 2016 2:26:09 PM

Page 6

Work Order ID: 154390

154390

Parent Item: 647.7328

647 7328

Parent Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016

Required Date: 12/16/2016

Start Qty: 1.00

Required Qty: 1.00

647.1405

Manufactured No

Each

0.0000

1

647 1405

Upper Cutter Assembly

153311

DEC 19 2016

DAS 28
6
9-89

Smf

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 9: T3/P3 UC Removable Provisions Kit, 647.7328

FIND #	PART #	DESCRIPTION	QTY
11	647.7701	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
39	601.3120	EYE BOLT	2
40	601.3119	CLEVIS	2
46	601.2826	BOLT	2
48	601.2669	BOLT	2
52	601.2973	LOCKNUT	2
54	601.3209	LOCKNUT	2
55	601.3128	NUT	2
61	601.2988	SCREW	2
85	601.2764	WASHER	19
87	601.3663	WASHER	4
88	601.3126	WASHER	2
91	601.2045	RTV	A/R
96	647.5701	GPS MOUNT KIT	1
100	601.2765	SCREW	5
101	601.1541	LOCKNUT	5
111	647.1405	CUTTER ASSY (UPPER)	1

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154390
DEC 15 2016

Work Order ID 154390

Friday, December 16, 2016 10:24:52 AM

154390

Page 1

Item ID: 647.7328

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC135 T3/P3 Upper Cutter Removable Provisions

Start Date: 12/12/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/16/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

MPP-195

N/C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP 647.7328

DEC 16 2016

DAS
21
9-25

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
*Engineering Clerk
Document Administrator*

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lmcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

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F +1-613-632-5146
+1-800-556-4166
www.dartaerospace.com

From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM



REFERENCE ONLY

SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 9: T3/P3 UC Removable Provisions Kit, 647.7328

FIND #	PART #	DESCRIPTION	QTY
11	647.7701	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
39	601.3120	EYE BOLT <i>A744-12A</i>	2
40	601.3119	CLEVIS <i>A7665-34R</i>	2
46	601.2826	BOLT <i>A73-11A</i>	2
48	601.2669	BOLT <i>A74C7A</i>	2
52	601.2973	LOCKNUT <i>MS21042-08</i>	2
54	601.3209	LOCKNUT <i>MS21042L4</i>	2
55	601.3128	NUT <i>A7316C4L</i>	2
61	601.2988	SCREW <i>MS27039-08-13</i>	2
85	601.2764	WASHER <i>NAS114F0832P</i>	19
87	601.3663	WASHER <i>NAS114F0432R</i>	4
88	601.3126	WASHER <i>NAS114F0532P</i>	2
91	601.2045	RTV	A/R
96	647.5701	GPS MOUNT KIT	1
100	601.2765	SCREW <i>MS27039-08J7</i>	5
101	601.1541	LOCKNUT <i>MS21042L08</i>	5
111	647.1405	CUTTER ASSY (UPPER)	1

w/a